

Date: Tuesday, 03/03/2009 4:15:30 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : TUBE
<b>Job Number</b> : 46272	
<b>Estimate Number</b> : 12243	
<b>P.O. Number</b> :	<b>Part Number</b> : D34773
<b>This Issue</b> : 03/03/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3477 REV.B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 44624	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 20/03/2009 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 09-03-04</u>	
<b>Comment</b> : Est Rev:A New Issue 06-02-07 JLM Est Rev:B 09-02-13 rev.b as per dwg DD verified by:EC	

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304S26GA

304/316 0.018 SHEET



**Comment:** Qty.: 0.1985 sf(s)/Unit Total : 0.7938 sf(s)  
 304/316 0.018 SHEET  
 (M304S26GA)  
 Batch: M 107021

FF 09-03-31

2.0

SHEAR

SHEAR

**Comment:** SHEAR

Cut as per Dwg D3477 (13.40" X 2.04")

FF 09-03-31

3.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2-Roll as per Dwg D3477

3-Tack Weld as per Dwg D3477

FF 09-04-01

4.0

QC11

VISUAL INSPECTION OF SPOT WELDING

**Comment:** VISUAL INSPECTION OF SPOT WELDING

SB 09/04/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 03/03/2009 4:15:30 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 46272

Part Number: D34773

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/04/03 (4)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: SS

9/6/2

(4x)

50

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/02

Job Completion



MF 09-06-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

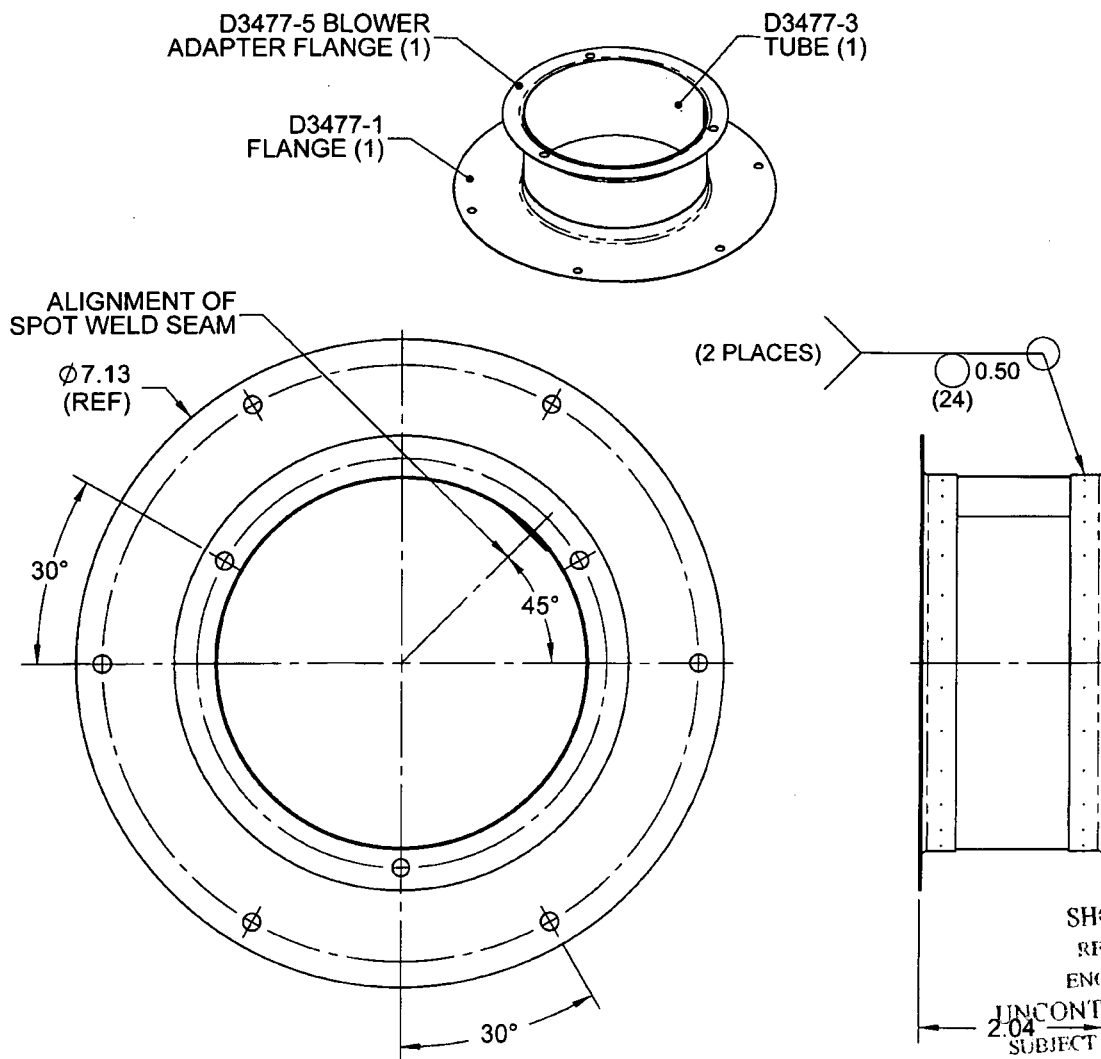
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART****RELEASED**  
8/01/20

DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3477</b>	REV. B SHEET 1 OF 4
DATE <b>08.12.19</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:2
A	05.12.09	NEW ISSUE	
B	08.12.19	$\phi 3.40$ & $\phi 4.1$ WERE $\phi 3.600$ & $\phi 4.14$ (SHT 2 & 4); ADD MFG NOTE AND TOL (SHT 3); MATL SPEC WAS MIL-S-5019	

**D3477-041 BLOWER MOTOR INLET ADAPTER****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3477-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3477-041	BLOWER MOTOR ASSEMBLY
1	D3477-1	FLANGE
1	D3477-3	TUBE
1	D3477-5	BLOWER ADAPTER FLANGE

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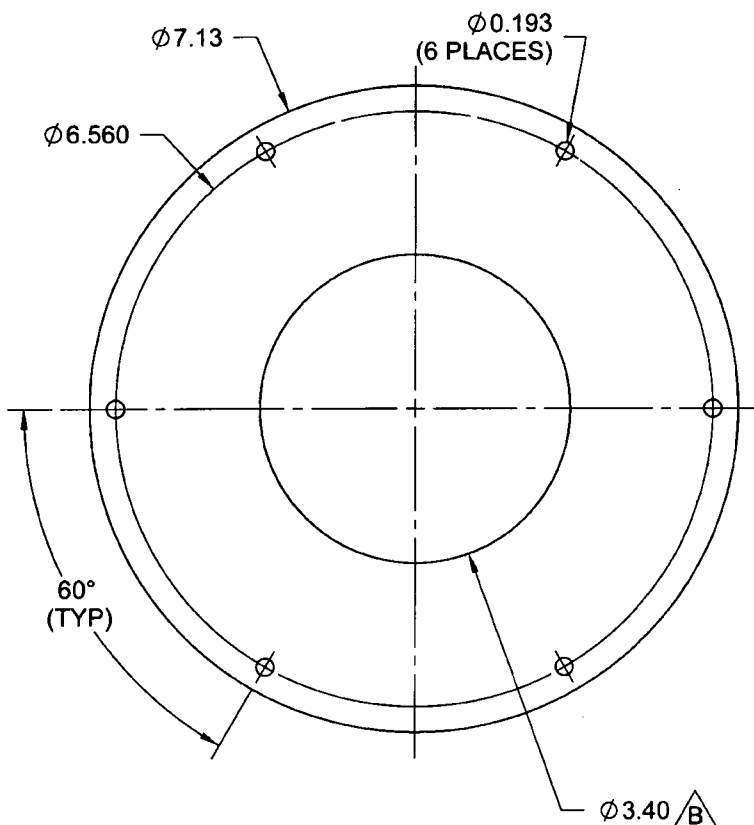
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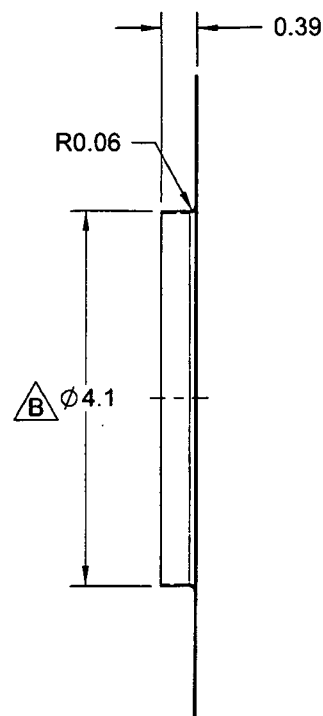


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DATE 08.12.19		TITLE BLOWER INLET ADAPTER	SCALE 1:2

RELEASED  
9/10/12 MP



**D3477-1F FLANGE  
FLAT PATTERN**



**D3477-1  
FLANGE**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH (OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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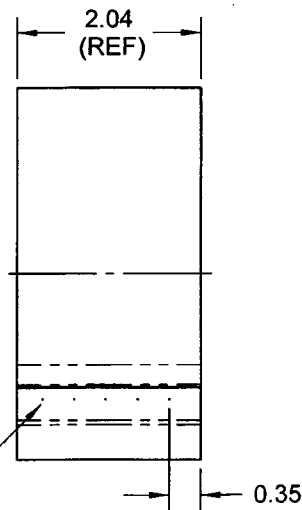
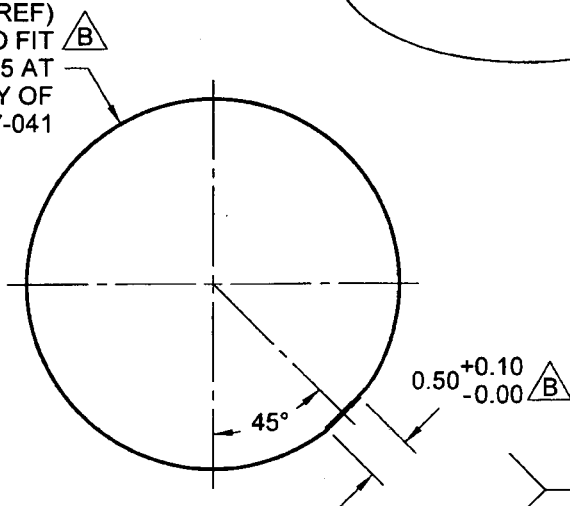
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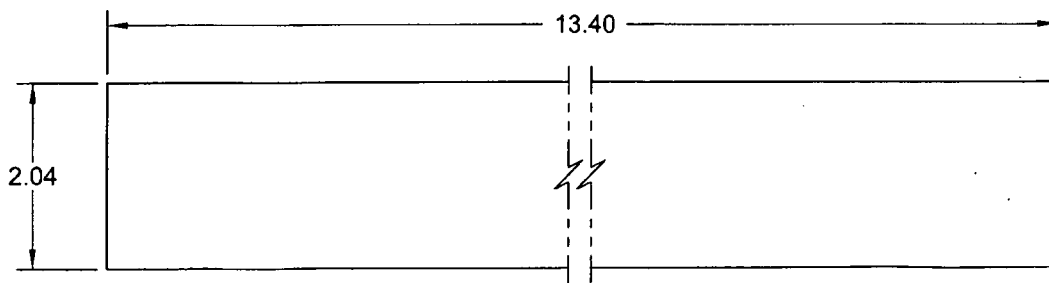
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DATE 08.12.19		TITLE BLOWER INLET ADAPTER	SCALE 1:2

RELEASED  
*[Signature]*

Ø4.10 (REF)  
FORM TO FIT  
D3477-1/-5 AT  
ASSY OF  
D3477-041



### D3477-3 TUBE



### D3477-3F TUBE FLAT PATTERN

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH  
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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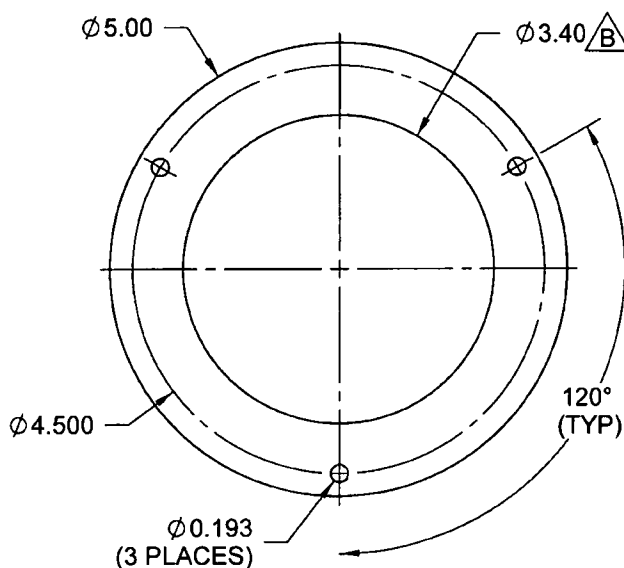
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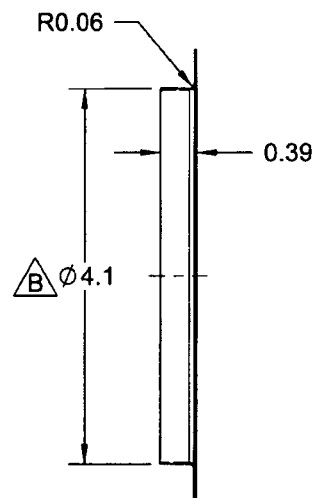


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DATE 08.12.19		TITLE BLOWER INLET ADAPTER	SCALE 1:2

RELEASED  
*01/01/20*



**D3477-5F FLAT PATTERN**



**D3477-5 BLOWER  
ADAPTER FLANGE**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH/BEERING  
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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**SPOT WELD TEST RECORD**  
**AMS-W-6858A**  
**CLASS 'C'**

**TEST NO#:** 62

**EMPLOYEE:** Frank Frank

**PART NUMBER:** D 3477-3

**JOB NUMBER:** B 46272

**MATERIAL TYPE:** 304L

**MATERIAL THICKNESS:** .018

**GROUP SPECIFICATION**



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium, SS

**TEST RESULTS**

	PASS	FAIL
VISUAL:	[ <input checked="" type="checkbox"/> ]	[ <input type="checkbox"/> ]
PENETRATION:	[ <input checked="" type="checkbox"/> ]	[ <input type="checkbox"/> ]
PULL STRENGTH:	[ <input checked="" type="checkbox"/> ]	[ <input type="checkbox"/> ]

PSI Reading: \_\_\_\_\_

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

**DATE OF TEST COUPON:** 09/04/02

**QUALIFIER:** SB